

Friday, 9/1/2006 12:07:00 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 02.500 SUPPORT
Job Number : 28389
Estimate Number : 11058
P.O. Number : *N/A* Part Number : D28921
This Issue : 9/1/2006 S.O. No. : *N/A* Drawing Number : D2892 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : *N/A* Type : PURCHASED PARTS Drawing Revision : A
Previous Run : 28078 Material : *N/A*
Written By : *[Signature]* Due Date : 9/29/2006 Qty: 20 Um: Each
Checked & Approved By : *[Signature]*
Comment : Est. C 02.11.26 Added P/O KJ

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *1954*

Description: D6104-003

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

Blank size makes (2) D2891-1

*C Loe 109/05**(20)*

2.0

D6104003

17-4 SS Roundbar 3.25"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Support

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

DB 06/09/13

4.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE

PG*Issue P/O 2008**C Loe 109/18 (20)*

Comment: MORI SEIKI LATHE

Turn blank for Haas as per Folio FA082

turn per DSK 077

5.0

QC1

INSPECT ALL DIM TO DIM SHEET

PG*Recieve & Inspect for**(20)*


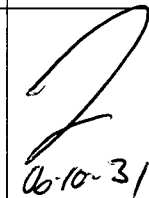
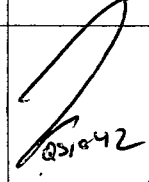
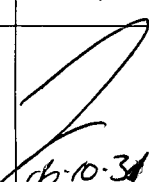
Comment: INSPECT ALL DIM TO DIM SHEET

*transit damage 8/16/04**56**Inspect level 5**EP 06/10/24 x20*

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PP Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|--|---|-----------------|--|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06/10/27 | 6 | 2 parts are have all the holes 0.020" more to one side the Dim 0.464 (AI) is 0.010 out of tolerance |  | tighen the J.G cause it moved. Parts are acceptable. I.D. with a wire, so installer know what parts are what. | J.G 06/10/27 |  06-10-31 |  06-10-31 |  06-10-31 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:07:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Bart Helicopters Services

Drawing Name: 02.500 SUPPORT

Job Number: 28389

Part Number: D28921

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

Machine as per Folio FA082
Tumble & Deburr

Er 06/10/23

J.G. 06/10/23 40

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Er 06/10/23

J.G. 06/10/23 40

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06/10/31 40

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 102391

M.H. / YL 06/12/22

(40x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/12/22 (40)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5+ 166*

CB 9/12/22 CU 1/4/22 (44)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07/10/22

Job Completion



C Loe 11/2/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-------------------------------------|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 28389 |
| Description: Ø2.500 Support | Part Number: | D2892-1 |
| Inspection Dwg: D2892 Rev. A | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| Lathe Section | | | | | | | | | |
| A | 2.524 | 2.529 | | 2.525 | 2.526 | 2.526 | 2.526 | | |
| B | 3.702 | 3.722 | | 3.712 | 3.713 | 3.712 | 3.712 | | |
| C | 2.814 | 2.834 | | 2.826 | 2.826 | 2.826 | 2.826 | | |
| D | 0.718 | 0.738 | | 0.726 | 0.727 | 0.728 | 0.727 | | |
| E | 0.090 | 0.110 | | 0.104 | 0.101 | 0.101 | 0.102 | | |
| F | 2.714 | 2.734 | | 2.723 | 2.723 | 2.724 | 2.724 | | |
| G | 2.029 | 2.049 | | 2.038 | 2.038 | 2.037 | 2.037 | | |
| H | 3.214 | 3.234 | | 3.225 | 3.226 | 3.225 | 3.225 | | |
| I | 0.913 | 0.933 | | 0.922 | 0.924 | 0.924 | 0.924 | | |
| J | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | | |
| K | 0.090 | 0.110 | | 0.093 | 0.092 | 0.092 | 0.092 | | |
| L | | | | | | | | | |
| HAAS Section | | | | | | | | | |
| AA | 0.115 | 0.135 | | 0.132 | 0.130 | 0.129 | 0.129 | | |
| AB | 0.290 | 0.310 | | 0.305 | 0.298 | 0.303 | 0.302 | | |
| AC | 0.040 | 0.060 | | 0.050 | 0.045 | 0.046 | 0.046 | | |
| AD | 0.115 | 0.135 | | 0.125 | 0.121 | 0.120 | 0.121 | | |
| AE | 0.240 | 0.260 | | 0.250 | 0.249 | 0.244 | 0.247 | | |
| AF | 0.188 | 0.193 | DT8706 | 0.190 | 0.190 | 0.190 | 0.190 | | |
| AG | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AH | 1.126 | 1.146 | | 1.148 | 1.145 | 1.145 | 1.145 | | |
| AI | 0.454 | 0.474 | | 0.464 | 0.464 | 0.460 | 0.464 | | |
| AJ | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AK | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AL | 0.257 | 0.262 | DT8883 | 0.259 | 0.260 | 0.260 | 0.260 | | |
| AM | 1.663 | 1.683 | | 1.667 | 1.674 | 1.673 | 1.667 | | |
| AN | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.062 | | |
| AO | 0.022 | 0.042 | | 0.032 | 0.037 | 0.032 | 0.032 | | |
| AP | 2.779 | 2.789 | | 2.781 | 2.780 | 2.781 | 2.785 | | |
| AQ | | | | | | | | | |
| AR | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|--------------|----------|
| Measured by: | J. G |
| Date: | 06/10/23 |

| | |
|-------------|----------|
| Audited by: | SD |
| Date: | 06.10.31 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 02.12.12 | New Issue | KJ/RF | |

| | | |
|-------------------------------------|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | |
| Description: Ø2.500 Support | Part Number: | D2892-1 |
| Inspection Dwg: D2892 Rev. A | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1/5 | 1/6 | 1/7 | 1/8 | By | Date |
| Lathe Section | | | | | | | | | |
| A | 2.524 | 2.529 | | 2.529 | 2.529 | 2.529 | 2.529 | | |
| B | 3.702 | 3.722 | | 3.714 | 3.716 | 3.713 | 3.710 | | |
| C | 2.814 | 2.834 | | 2.822 | 2.822 | 2.823 | 2.829 | | |
| D | 0.718 | 0.738 | | 0.725 | 0.720 | 0.725 | 0.722 | | |
| E | 0.090 | 0.110 | | 0.093 | 0.096 | 0.098 | 0.101 | | |
| F | 2.714 | 2.734 | | 2.723 | 2.724 | 2.723 | 2.724 | | |
| G | 2.029 | 2.049 | | 2.037 | 2.035 | 2.036 | 2.044 | | |
| H | 3.214 | 3.234 | | 3.221 | 3.222 | 3.221 | 3.223 | | |
| I | 0.913 | 0.933 | | 0.927 | 0.930 | 0.928 | 0.928 | | |
| J | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | | |
| K | 0.090 | 0.110 | | 0.097 | 0.098 | 0.097 | 0.097 | | |
| L | | | | | | | | | |
| HAAS Section | | | | | | | | | |
| AA | 0.115 | 0.135 | | 0.129 | 0.130 | 0.128 | 0.131 | | |
| AB | 0.290 | 0.310 | | 0.302 | 0.305 | 0.305 | 0.301 | | |
| AC | 0.040 | 0.060 | | 0.047 | 0.050 | 0.044 | 0.044 | | |
| AD | 0.115 | 0.135 | | 0.126 | 0.122 | 0.121 | 0.124 | | |
| AE | 0.240 | 0.260 | | 0.249 | 0.250 | 0.249 | 0.251 | | |
| AF | 0.188 | 0.193 | DT8706 | 0.190 | 0.190 | 0.190 | 0.190 | | |
| AG | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AH | 1.126 | 1.146 | | 1.143 | 1.143 | 1.143 | 1.143 | | |
| AI | 0.454 | 0.474 | | 0.465 | 0.465 | 0.462 | 0.467 | | |
| AJ | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AK | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AL | 0.257 | 0.262 | DT8683 | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AM | 1.663 | 1.683 | | 1.676 | 1.676 | 1.674 | 1.672 | | |
| AN | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AO | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | | |
| AP | 2.779 | 2.789 | | 2.784 | 2.784 | 2.782 | 2.783 | | |
| AQ | | | | | | | | | |
| AR | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|--------------|----------------|
| Measured by: | En [Signature] |
| Date: | 06.10.21 |

| | |
|-------------|----------------|
| Audited by: | SA [Signature] |
| Date: | 06.10.21 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-------------------|-------------|
| A | 02.12.12 | New Issue | KJ/RF [Signature] | [Signature] |

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|-------------------------------------|--|-----------------------------|--|
| DART AEROSPACE LTD | | Work Order: | |
| Description: Ø2.500 Support | | Part Number: D2892-1 | |
| Inspection Dwg: D2892 Rev. A | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|----------------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| Lathe Section | | | | | | | | | |
| A | 2.524 | 2.529 | | 2.529 | 2.529 | 2.529 | 2.529 | | |
| B | 3.702 | 3.722 | | 3.714 | 3.712 | 3.712 | 3.712 | | |
| C | 2.814 | 2.834 | | 2.822 | 2.823 | 2.821 | 2.824 | | |
| D | 0.718 | 0.738 | | 0.721 | 0.721 | 0.726 | 0.726 | | |
| E | 0.090 | 0.110 | | 0.095 | 0.097 | 0.093 | 0.093 | | |
| F | 2.714 | 2.734 | | 2.718 | 2.723 | 2.721 | 2.722 | | |
| G | 2.029 | 2.049 | | 2.038 | 2.035 | 2.036 | 2.037 | | |
| H | 3.214 | 3.234 | | 3.223 | 3.222 | 3.223 | 3.223 | | |
| I | 0.913 | 0.933 | | 0.920 | 0.916 | 0.922 | 0.927 | | |
| J | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | | |
| K | 0.090 | 0.110 | | 0.098 | 0.097 | 0.097 | 0.096 | | |
| L | | | | | | | | | |
| HAAS Section | | | | | | | | | |
| AA | 0.115 | 0.135 | | 0.128 | 0.129 | 0.131 | 0.130 | | |
| AB | 0.290 | 0.310 | | 0.306 | 0.306 | 0.297 | 0.305 | | |
| AC | 0.040 | 0.060 | | 0.050 | 0.044 | 0.048 | 0.044 | | |
| AD | 0.115 | 0.135 | | 0.120 | 0.121 | 0.120 | 0.119 | | |
| AE | 0.240 | 0.260 | | 0.246 | 0.251 | 0.249 | 0.246 | | |
| AF | 0.188 | 0.193 | DT8706 | 0.190 | 0.190 | 0.190 | 0.190 | | |
| AG | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AH | 1.126 | 1.146 | | 1.143 | 1.144 | 1.143 | 1.143 | | |
| AI | 0.454 | 0.474 | | 0.464 | 0.461 | 0.464 | 0.464 | | |
| AJ | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AK | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AL | 0.257 | 0.262 | DT8683 | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AM | 1.663 | 1.683 | | 1.678 | 1.674 | 1.667 | 1.671 | | |
| AN | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AO | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | | |
| AP | 2.779 | 2.789 | | 2.780 | 2.781 | 2.783 | 2.781 | | |
| AQ | | | | | | | | | |
| AR | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|--------------|---------------------|
| Measured by: | En |
| Date: | 06/10/24 / 06/10/25 |

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|-------------|----------|
| Audited by: | SA |
| Date: | 06.10.21 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 02.12.12 | New Issue | KJ/RF | |

| | | |
|-------------------------------------|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | |
| Description: Ø2.500 Support | Part Number: | D2892-1 |
| Inspection Dwg: D2892 Rev. A | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|----------------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 13 | 14 | 15 | 16 | | |
| Lathe Section | | | | | | | | | |
| A | 2.524 | 2.529 | | 2.529 | 2.529 | 2.529 | 2.529 | | |
| B | 3.702 | 3.722 | | 3.714 | 3.712 | 3.713 | 3.715 | | |
| C | 2.814 | 2.834 | | 2.822 | 2.823 | 2.822 | 2.821 | | |
| D | 0.718 | 0.738 | | 0.722 | 0.723 | 0.727 | 0.720 | | |
| E | 0.090 | 0.110 | | 0.093 | 0.101 | 0.094 | 0.096 | | |
| F | 2.714 | 2.734 | | 2.723 | 2.720 | 2.724 | 2.721 | | |
| G | 2.029 | 2.049 | | 2.036 | 2.038 | 2.032 | 2.032 | | |
| H | 3.214 | 3.234 | | 3.222 | 3.223 | 3.224 | 3.222 | | |
| I | 0.913 | 0.933 | | 0.927 | 0.921 | 0.928 | 0.927 | | |
| J | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | | |
| K | 0.090 | 0.110 | | 0.098 | 0.099 | 0.097 | 0.098 | | |
| L | | | | | | | | | |
| HAAS Section | | | | | | | | | |
| AA | 0.115 | 0.135 | | 0.129 | 0.128 | 0.129 | 0.129 | | |
| AB | 0.290 | 0.310 | | 0.308 | 0.303 | 0.307 | 0.307 | | |
| AC | 0.040 | 0.060 | | 0.046 | 0.045 | 0.049 | 0.049 | | |
| AD | 0.115 | 0.135 | | 0.120 | 0.119 | 0.120 | 0.121 | | |
| AE | 0.240 | 0.260 | | 0.244 | 0.246 | 0.246 | 0.245 | | |
| AF | 0.188 | 0.193 | DT8706 | 0.190 | 0.190 | 0.190 | 0.190 | | |
| AG | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AH | 1.126 | 1.146 | | 1.144 | 1.143 | 1.142 | 1.141 | | |
| AI | 0.454 | 0.474 | | 0.465 | 0.464 | 0.464 | 0.462 | | |
| AJ | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AK | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AL | 0.257 | 0.262 | DT8689 | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AM | 1.663 | 1.683 | | 1.667 | 1.670 | 1.669 | 1.668 | | |
| AN | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AO | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | | |
| AP | 2.779 | 2.789 | | 2.782 | 2.782 | 2.782 | 2.782 | | |
| AQ | | | | | | | | | |
| AR | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|---|
| Measured by: <u>En</u> |
| Date: <u>06/10/26</u> / <u>06/10/26</u> |

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|-----------------------|
| Audited by: <u>SA</u> |
| Date: <u>06.10.31</u> |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 02.12.12 | New Issue | KJ/RF | <u>+</u> |

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|-------------------------------------|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | |
| Description: Ø2.500 Support | Part Number: | D2892-1 |
| Inspection Dwg: D2892 Rev. A | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|----------------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 17 | 18 | 19 | 20 | | |
| Lathe Section | | | | | | | | | |
| A | 2.524 | 2.529 | | 2.529 | 2.529 | 2.529 | 2.529 | | |
| B | 3.702 | 3.722 | | 3.711 | 3.702 | 3.715 | 3.712 | | |
| C | 2.814 | 2.834 | | 2.823 | 2.823 | 2.824 | 2.821 | | |
| D | 0.718 | 0.738 | | 0.725 | 0.727 | 0.726 | 0.724 | | |
| E | 0.090 | 0.110 | | 0.093 | 0.102 | 0.094 | 0.095 | | |
| F | 2.714 | 2.734 | | 2.722 | 2.720 | 2.722 | 2.722 | | |
| G | 2.029 | 2.049 | | 2.035 | 2.036 | 2.036 | 2.038 | | |
| H | 3.214 | 3.234 | | 3.221 | 3.220 | 3.222 | 3.223 | | |
| I | 0.913 | 0.933 | | 0.922 | 0.914 | 0.921 | 0.926 | | |
| J | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | | |
| K | 0.090 | 0.110 | | 0.098 | 0.098 | 0.098 | 0.099 | | |
| L | | | | | | | | | |
| HAAS Section | | | | | | | | | |
| AA | 0.115 | 0.135 | | 0.128 | 0.129 | 0.128 | 0.129 | | |
| AB | 0.290 | 0.310 | | 0.304 | 0.305 | 0.304 | 0.304 | | |
| AC | 0.040 | 0.060 | | 0.051 | 0.051 | 0.051 | 0.050 | | |
| AD | 0.115 | 0.135 | | 0.129 | 0.128 | 0.129 | 0.129 | | |
| AE | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AF | 0.188 | 0.193 | DT8706 | 0.190 | 0.190 | 0.190 | 0.190 | | |
| AG | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AH | 1.126 | 1.146 | | 1.144 | 1.144 | 1.145 | 1.145 | | |
| AI | 0.454 | 0.474 | | 0.464 | 0.464 | 0.465 | 0.460 | | |
| AJ | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | | |
| AK | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AL | 0.257 | 0.262 | DT8683 | 0.258 | 0.258 | 0.258 | 0.258 | | |
| AM | 1.663 | 1.683 | | 1.677 | 1.677 | 1.677 | 1.677 | | |
| AN | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AO | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | 0.032 | | |
| AP | 2.779 | 2.789 | | 2.782 | 2.782 | 2.781 | 2.788 | | |
| AQ | | | | | | | | | |
| AR | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| |
|---------------------------------------|
| Measured by: <i>En / S-G</i> |
| Date: <i>06/10/24</i> <i>06/10/26</i> |

| |
|-----------------------|
| Audited by: <i>SD</i> |
| Date: <i>06.10.21</i> |


| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 02.12.12 | New Issue | KJ/RF | <i>[Signature]</i> |

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



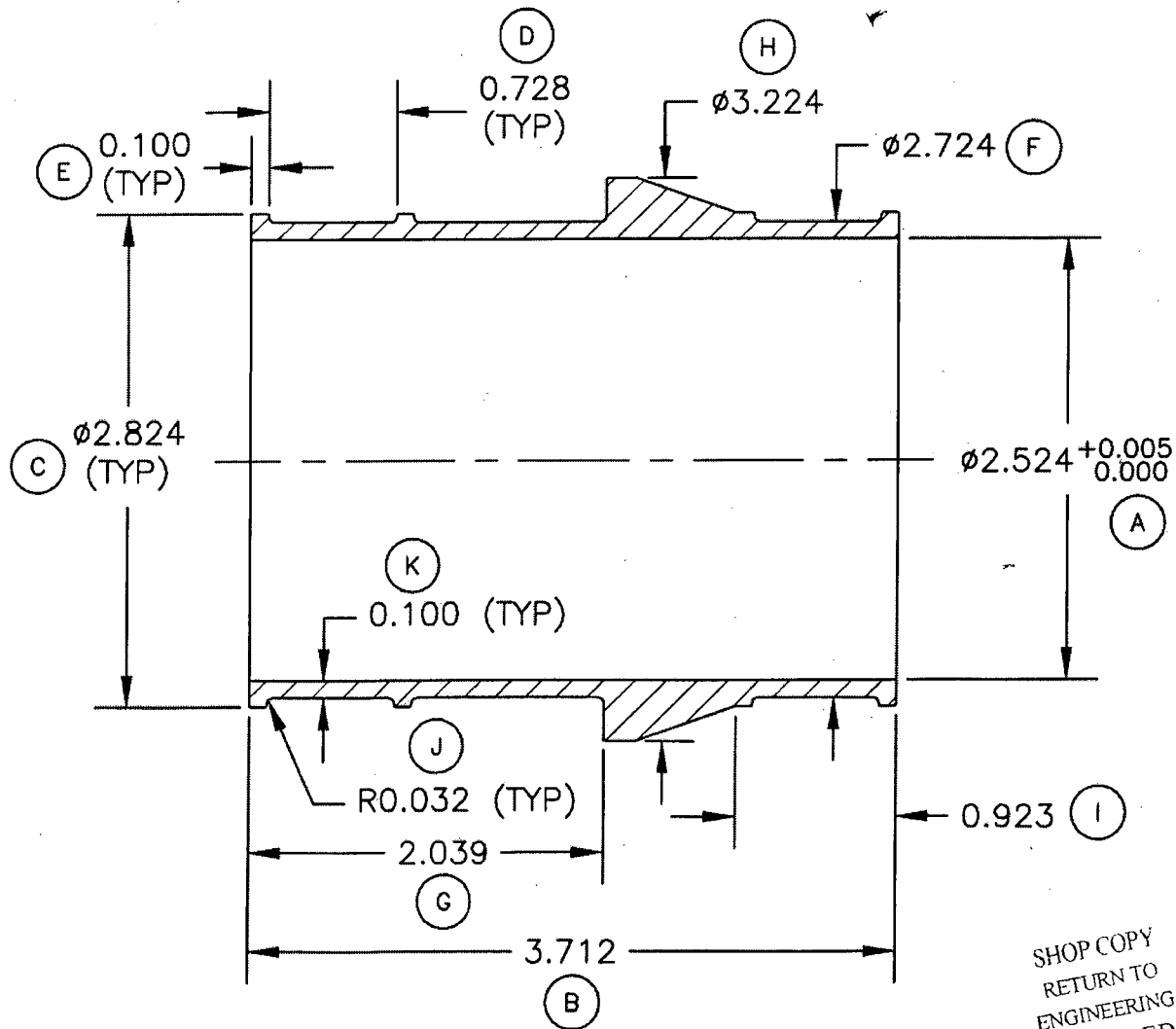
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| | | | | |
|---------|-----------|----------|--|--------------|
| A | 00.11.17 | | NEW ISSUE | |
| DESIGN | <i>CP</i> | DRAWN BY |  DART AEROSPACE LTD. <small>HARRISBURY, ONTARIO, CANADA</small> | |
| CHECKED | <i>CP</i> | APPROVED | DRAWING NO. | REV. A |
| | | | D2892 | SHEET 1 OF 1 |
| DATE | 00.11.17 | | TITLE | SCALE |
| | | | Ø2.500 SUPPORT | 1:1 |

DART

| | | | |
|------------------|----------------|---|------------------------|
| DESIGN TF | DRAWN BY TF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. DSK 077 | REV. A SHEET 1 OF 1 |
| DATE 03.05.20 | | TITLE TURNING DETAIL FOR D2892-1 | SCALE 1:1 |
| A | 03.05.20 | NEW ISSUE | |

RELEASED
07.07.01

D2892-1 TURNING DETAIL

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**VENUS****VENUS WIRE INDUSTRIES LIMITED**

REGD.OFFICE : 19 Raghunath Mill Compound, S. B. Marg, Lower Parel, Mumbai- 400 013, (INDIA)

Tel.: 91-22-24978840 Fax : 91-24978846 E-mail : Sales@Venuswires.com Website : WWW.Venuswires.com

ISO: 9001:2000

REGISTERED FIRM

INSPECTION /MILL/QUALITY CERTIFICATE

No. BB/VW/2006-2007/0765

| | | | | | | | | | | | | | | |
|---|--------------------------|--------------------------------|---------------|---------------|----------------|----------------|-----------------|--------------|--------------|----------------|--------------------|----------------|--------------|--|
| PRODUCT INFORMATION | CUSTOMER | : M/S. AMS SPECIALTY INC. | | | | | | | GRADE | : AISI-630 | | | | |
| | INVOICE NO. | : PM/042/EXP/2006-2007 | | | | | | | HEAT NO. | : VBMU-0622 | | | | |
| | PRODUCT FORM | : STAINLESS STEEL BRIGHT BARS | | | | | | | | | | | | |
| | DIMENSION | : 3 1/4"S.A. Tol :- +/- 0.003" | | | | | | | QUANTITY | : 2050.30 LBS | | | | |
| | IDENTIFICATION | : AJ 2546 | | | | | | | | | | | | |
| CONDITION : ANNEALED,PEELED CENT.GROUND & POLISHED | | | | | | | | | | | | | | |
| CHEMICAL COMPOSITION | ELEMENTS | C% | Si% | Mn% | P% | S% | Cr% | Ni% | Cu% | Mo% | N% | Nb% | Nb+TA | |
| | SPECIFIED MIN MAX | ----- 0.07 | ----- 1.00 | ----- 1.00 | ----- 0.040 | ----- 0.030 | 15.00 17.50 | 3.00 5.00 | 3.00 5.00 | ----- ----- | ----- ----- | ----- ----- | 0.15 0.45 | |
| | RESULTS | 0.032 | 0.370 | 0.680 | 0.033 | 0.022 | 15.500 | 4.300 | 3.200 | 0.050 | 0.024 | 0.290 | 0.2904 | |
| MECHANICAL PROPERTIES | UTS | | YS | | R.A. % | | ELONGATION % | | HARDNESS | | | | | |
| | RESULTS 138.19 KSI | | 122.87 KSI | | 31.75 | | 11.17 | | 306 BHN | | | | | |
| HEAT TREATMENT: 1900°F SOLUTION ANNEALED RAPID COOLED. | | | | | | | | | | | | | | |
| REMARKS : <ul style="list-style-type: none">* CONTACT PROBE THERMOCOUPLES USED TO DETERMINE CHARGE TEMPRATURE.* MATERIAL IS FREE FROM MERCURY AND RADIUM CONTAMINATION.* NO WELDING PERFORMED.* DISC MACROETCHED AND NO PIPE OR CRACK OBSERVED.* MATERIAL PRODUCED WITHOUT OZONE DEPLETING SUBSTANCES.* MICROSTRUCTURE : 2.08% FERRITE.* MELTING PRACTICE EAF CONVERTOR TO VOD.* MATERIAL CONFORMS TO ASTM A564/A564-02A TYPE 630, CONDITION A, ASTM A370-03A, ASTM E340, ASME SA564/SA564M, AMS 5643Q,* THIS CERTIFICATE IS ACCORDING TO EN 10204/3.1B* AMS ORDER NO : 4277* COPPER & BRASS ORDER NO. : CJ5743* COUNTRY OF ORIGIN : INDIA | | | | | | | | | | | | | | |
| We hereby certify that the material described herein has been manufactured and tested with satisfactory results in accordance with the customers requirements, needs and expectations. Mechanical test results is the one result taken randomly from the lot. | | | | | | | | | | | (MANAGER Q.A.) | | | |
| DATE: 18/07/2006 | | | | | | | | | | | | | | |

DOC.No. F/QAD/06,R1

PLANT : ATKARGAON, TAKAI ADOSHI ROAD, KHALAPUR, KHOPOLI- 410203.
PHONES : 02192-262334/263404/262610 FAX : (02192) 2668873

For any information / query please quote Invoice No. & TC No. / Invoice No. & Bundle No.



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

| <u>QUANTITY</u> | <u>PART NUMBER</u> | <u>PART NAME</u> | <u>P.O. NUMBER</u> |
|-----------------|--------------------|---|--------------------|
| 10 | DSK076 | Support as per Dwg DSK076 D6104-003 B28388 | 2068 |
| 8 | DSK076 | Support as per Dwg DSK076 D6104-003 B28077 | 2068 |
| 10 | DSK076 | Support as per Dwg DSK076 D6104-003 B26715 | 2068 |
| 20 | DSK077 | Support as per Dwg DSK077 D6104-003 B28389 | 2068 |
| 8 | DSK077 | Support as per Dwg DSK077 D6104-003 B27970 | 2068 |
| 7 | DSK077 | Support as per Dwg DSK077 D6104-003 B28078 | 2068 |
| 14 | DSK080 | Support as per Dwg DSK080 D6104-011 B27266 | 2068 |

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, September 20, 2006

